

Date: Wednesday, 14/05/2008 10:01:43 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 39257		
Estimate Number	: 10707		
P.O. Number	:	Part Number	: D2012105
This Issue	: 14/05/2008 S.O. No. :	Drawing Number	: D2012-105 REV D1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 14/05/2008 Type : SMALL /MED FAB	Drawing Revision	: D1
Previous Run	: 37042	Material	:
Written By	:	Due Date	: 22/05/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.5.14</u>		
Comment	: Est Rev: 02.04.03 Added Inspect level 3 NG		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0500W035

304 RD Tube .500 x .035W



Comment: Qty.: 2.7567 f(s)/Unit Total: 27.5667 f(s)

Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Identify as D2012-101

Batch: M107967SB 08/05/20

2.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Punch to length as per Dwg D2012-105 & template D2012-105T1

SB 08/05/20 (10)

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SB 08/05/20 (10)

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/05/20 (10)

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

8:00
320°FM-J 08/05/21

(10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/05/2008 10:01:43 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 39257

Part Number: D2012105

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

8:30

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/05/21 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 226

JS 08/05/21 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22

Job Completion



umf 08-05-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

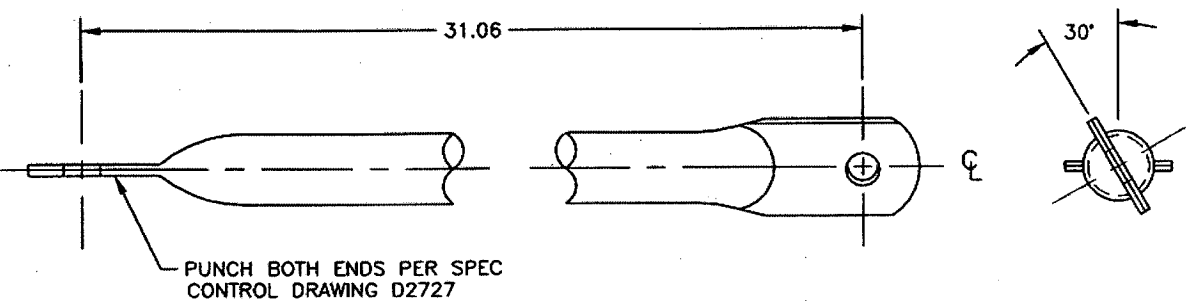
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
48/05/05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. D
CHECKED <i>MM</i>	APPROVED <i>KE</i>	DRAWING NO. D2012-105	SHEET 1 OF 1
DATE 98.04.28		TITLE ARM	SCALE NTS
A	92.06.04	NEW ISSUE - DRAWN FROM D2012	
B	96.06.25	30° ANGLE ROTATED 60° CCW	
C	97.09.03	CORRECTED VIEWS PER TSR A374	
D	98.04.28	ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
D1	97.03.25	ADD FINISH	

**NOTES:**

1. MAKE PER TEMPLATE DT8116 (WAS D2012-105)
MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART. QSI 005 4.3

ENGINEERING
RETURN TO
SHOP COPY
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39257

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries